

Work Order ID 117244

\*117244\*

Page 1

April-24-14 10:17:31 AM

Item ID: D2535

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Spring

Start Date: 4/30/14

Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 4/30/14

Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan: MCJDate: 14-04-29

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2535

Rev A

100

0.00

\*100\*

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 2407 Possible Supplier: Victoria Spring, 0.070 SS Torsion SpringCY 14/04/30 50

110

0.00

\*110\*

Receive &amp; Inspect for Damage &amp; Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

14/04/19 (50)

120

0.00

\*120\*

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Check dims to dwg

DAG  
27  
3-89  
14/5/1250

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117244

\*117244\*

Page 2

April-24-14 10:17:31 AM

Item ID: D2535

Revision ID:

Item Name: Spring

Start Date: 4/30/14

Required Date: 4/30/14

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Start Qty: 50.00

\*50\*

Cust Item ID:

Req'd Qty: 50.00

\*50\*

Customer:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

81011

0.00

\*130\*

Packaging

Memo

0.00

Packaging

50X

14-5-13

140

QC21 - Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

MCJ

14-05-13

14-5-13

DAS  
26  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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# Picklist Print

April-24-14 10:17:34 AM

Page 1

Work Order ID: 117244

**\*117244\***

Parent Item: D2535

**\*D2535\***

Parent Item Name: Spring

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P <b>*D2535P*</b> Spring		Purchased		No		100	Each	0.0000	1	50			
									**				

*44/0/9 (50)*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

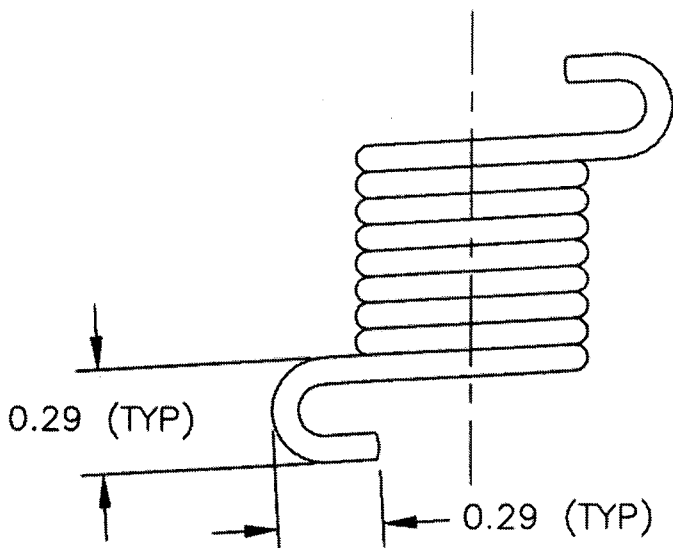
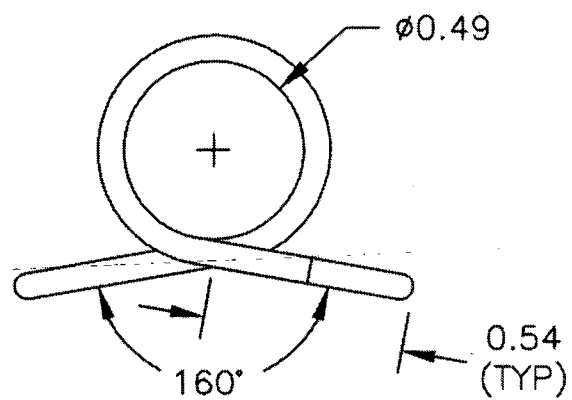
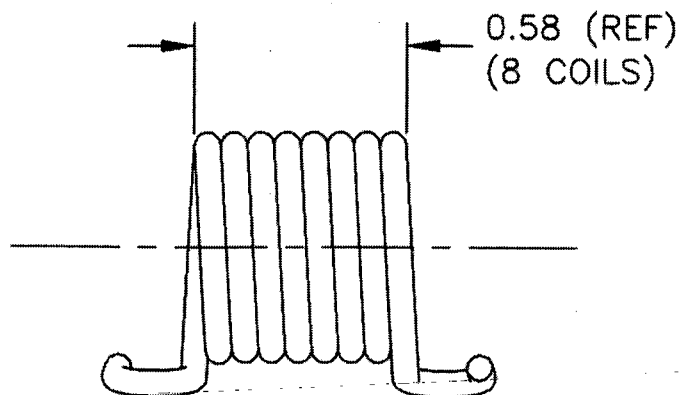
### FAULT CATEGORY

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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08	TITLE SPRING SPEC CONTROL		SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED  
99.05.11 KE



11724 M.S  
57W h2t11  
6240-41

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL  $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO24017**

Purchase Order Date 4/30/2014

PO Print Date 4/30/2014

Page Number 1 of 1

Order From :  
VICTORY SPRING LTD.  
#2 6104 - 82 AVE.  
EDMONTON, AB T6B 0E7  
CA

VC-VIC002

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
CZ 4/30

Contact Name	Buyer	Chantal Lavoie
Vendor Phone 866 230 5312	Customer POID	
	Customer Tax #	10127-2607
Ship To Contact	Terms	Net 30
Ship To Phone	Currency	CAD
Ship Via: FedEx PI collect	FOB	Destination-Collect
Ship Acct:		

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2535P	Spring	5/16/2014 Yes 5/16/2014		50.00 Each	\$4.56	\$228.00
	ASPER DWG D2535 REV. A B117244						
						Line Total:	\$228.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	5/16/2014  No 5/16/2014		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A026 certification of material conformance A042 dart notification by supplier A043 retention of quality document						
						Line Total:	\$0.00
						PO Total:	\$228.00

CZ mg

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Change Nbr: 1

Change Date: 4/30/2014





convenient. consistent. correct.

# PACKING SLIP 29754

#2, 6104 - 82 Ave  
Edmonton, AB T6B 0E7  
t + 780 442 4020  
f + 780 466 8000

**BILL TO:**  
Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

**SHIP TO:**  
Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

DATE		ORDER No.		SHIP VIA	
May 07, 2014		PO24017			
QUANTITY	DESCRIPTION			UNIT	AMOUNT
50	VIC 1533 D2535P Spring - Torsion				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

## CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 5/7/2014
PART/DRAWING #: D2535P VIC 1533	PO # 24017
DESCR: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	.492"	
Coil O.D.		.636"	
Number of Coils	8 ref	7.9	
Overall Length		1.12	
End Type	per dwg	yes	
Helix	RHW	RHW	

### COMMENTS

Mill Certificate attached: no  
Material Heat Number: 35791

Inspected by: *Jeremy Burrows*